

Date: Friday, 09/05/2008 1:42:33 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SKIDTUBE ASSEMBLY
Job Number :	39147	Part Number :	D205634011
Estimate Number :	10022	Drawing Number :	N/A
P.O. Number :		Project Number :	N/A
This Issue :	09/05/2008	Drawing Revision :	N/A
Prsht Rev. :	NC	Material :	
First Issue :	/ /	Due Date :	30/05/2008
Previous Run :	39146	Qty:	1 Um: Each
Written By :			
Checked & Approved By :	JLD 08.5.09		
Comment :	Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D205-634-011 CHG005

5 08/15/30 JLD
08.5.14

2.0	39147A	SKID TUBE ASSEMBLY
-----	--------	--------------------



Comment: Sub-Component SKID TUBE ASSEMBLY
 D205-634-041 B 39147A

SD

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

4.0	K10003	Saddle, D205-634-011
-----	--------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	K10003	Saddle Kit	37102

8/15/30

SP

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

5 08/15/30 62

RELEASED
07-06-28

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{4}$

Technical drawing of a bolted joint assembly. The drawing shows a circular cross-section of a component with a central hole. A bolt is shown passing through the hole, secured with a washer and a cap. The following labels and dimensions are present:






- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to the two locations where the cap is installed.
- SEAL WITH SIKAFLEX-241/-291**: Points to the sealant applied around the bolt head.
- AN3-5A BOLT (1)**: Points to the bolt.
- AN96QJD10L WASHER (1)**: Points to the washer.
- (2 PLACES)**: Points to the two locations where the washer is installed.
- D2855 CAP**: Points to the cap.
- 0.208**: Dimension indicating the diameter of the hole.
- 0.40**: Dimension indicating the thickness of the component.

Diagram of a circular part with a cross-section showing internal features. Labels include: D2579 SPACER, D2596 WEB (REF), and ALS7-1032-130 (REF) (TYP 50 PLACES). A note states: AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY: 1. CHAMFER HOLE 0.050 X 45° 2. INSERT D2579 SPACER (20 PLACES) 3. WELD INTO PLACE AND GRIND FLUSH 4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP. A triangle with the number 5 is also present.

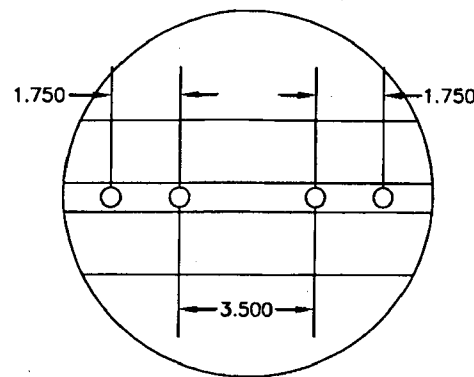
i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

[illegible][illegible]

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 391977

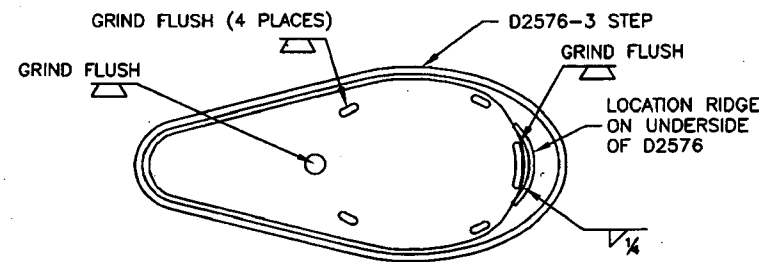
COPYRIGHT © 1996 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	DESIGN 	DRAWN BY 		DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
	CHECKED 	APPROVED 	DRAWING NO. D2580	REV. D SHEET 2 OF 3
	DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24

DETAIL E
SCALE 5:24

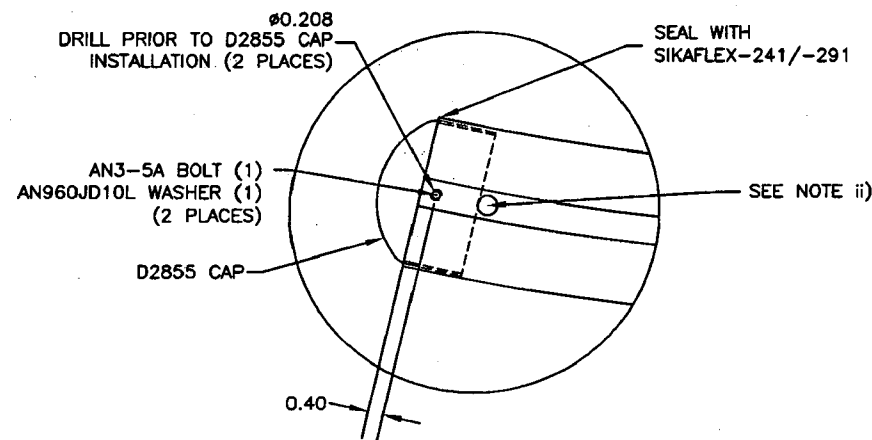


RELEASED
07.02.27

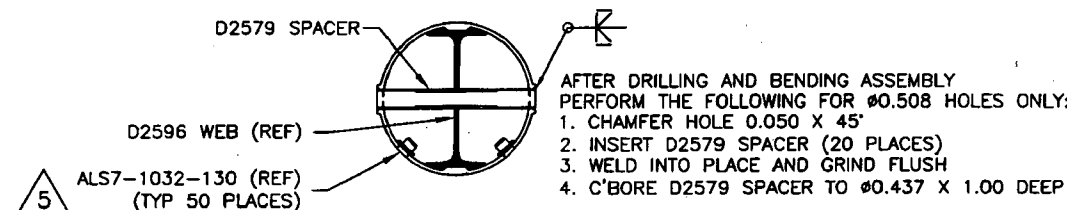
DETAIL F
SCALE 5:24



DETAIL G
SCALE 5:24



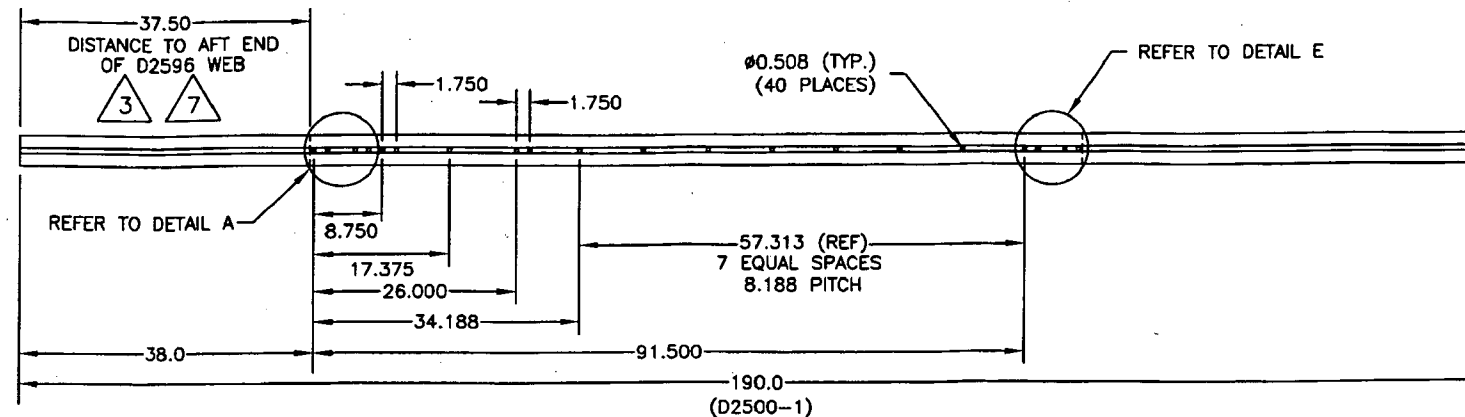
SECTION H-H
SCALE 5:24



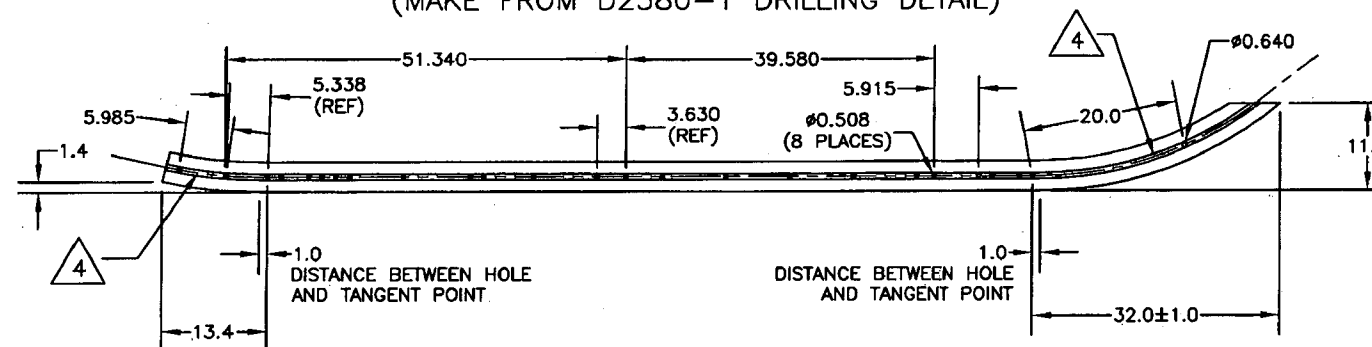
D2580-045 NOTES

- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

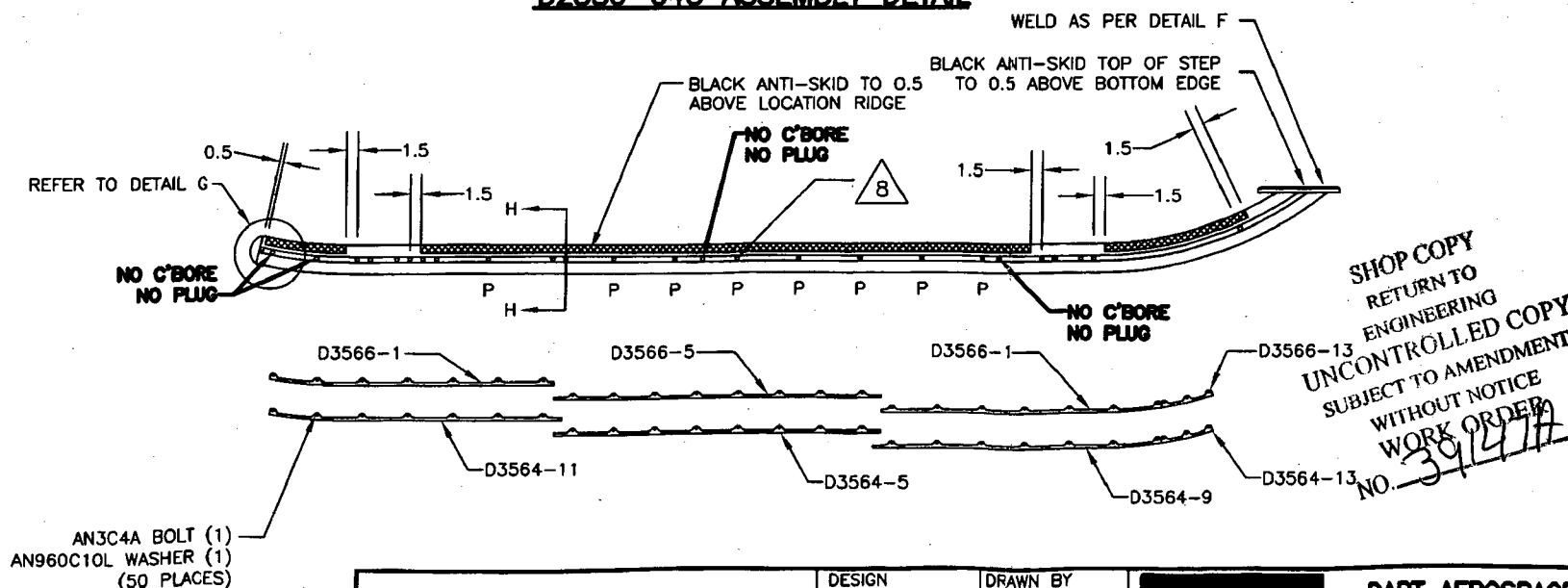
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



COPYRIGHT © 1996 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN RH	DRAWN BY RH	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

